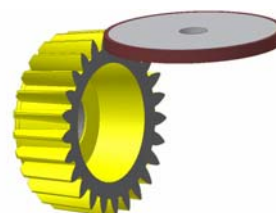











## Shaper Cutter Ø135 Z71

A12-210

To achieve an excellent surface finish - Ra less than 0.2, runout less than 0.005 mm - , a roughing and finishing wheel is used. In function of the diameter of the tool 200 to 500 rpm are needed for the face grinding, which requires a fast A-Axis. The below calculated time is considering 0.25 mm material removal.



### 1. Cycletime for Resharpener

Tool specifications					
Diameter 135 mm, Z 71, Grinding Length 20 - 25 mm					
Material HSS					
Operations					
Feed [mm/Min]	2000	150	180	150	200
Power [kW]		4	2	2	1
Cutting feed [m/s]		18	16	32	24
Used wheels					
Grinding time [s]	17	144	706	144	100
Total cycle time	18 Min 30				

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

8	1A1 Ø150 C120
1	1A1 Ø150 C180



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR, Dressing Unit, A-Rapid  
 Control: Fanuc 310i  
 Coolant: Synthetic Oil, pressure 6 bar  
 Software: Quinto 5

responsible engineer: OP,23.4.10

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